

Nuts N' Bolts[®] 128

Product Description

Hernon[®] Nuts N' Bolts[®] 128 is a single component, low strength thread locker designed for locking plastic and metal fasteners. Fixture time is about 5 minutes and adhesive can be pre or post applied.

Any excess adhesive on the surface will cure and will not migrate to the other parts. **Nuts N' Bolts[®] 128** can be used as a low strength thread locker, bonder or tamper proofer for metal, polyester, nylon and many other thermo plastics materials.

Typical Properties (Uncured)

| Property | Value |
|-----------------------------|---------------------|
| Chemical Type | Cyanoacrylate ester |
| Appearance | Blue liquid |
| Viscosity @ 77°F (25°C), cP | 60 - 90 |
| Specific gravity | 1.07 |
| Flash point | See SDS |

Typical Properties (Cured)

| Property | Value |
|----------------------------|------------------------|
| Temperature Range, °C (°F) | -54 to 85 (-65 to 185) |
| Set Time, Steel* | 8-10 minutes |
| Gap Filling | 0.004 in. |

*Set time can be speeded up with use of Activator 58.

Typical Cured Performance

Adhesive Properties

Cured for 24 hours and tested at 22°C on 3/8 x 24 grade 5 bolts and type 2 nuts according to ASTM D5363.

| Substrate | Breakaway | Prevail |
|-----------|--------------|--------------|
| | N•m (in-lb) | N•m (in-lb) |
| Steel | ≥ 2.8 (≥ 25) | ≥ 2.8 (≥ 25) |
| Plated | ≥ 2.8 (≥ 25) | ≥ 2.8 (≥ 25) |

General Information

This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be selected as a sealant for chlorine or other strong oxidizing materials.

For safe handling information on this product, consult the Safety Data Sheet (SDS).

Directions for use

1. For best performance bond surfaces should be clean and free from grease.
2. This product performs best in thin bond gaps (0.05 mm).
3. For Sealing Applications, apply a 360° bead of product to the leading threads of the male fitting, leaving the first thread free. Apply the nut and tighten as required. For fixtures, apply several drops of sealant down the internal threads to the bottom of the hole.
4. To prevent the sealant from clogging in the nozzle, do not allow the tip to touch bonding surfaces during application.
5. Excess adhesive can be dissolved with **Hernon[®] CA Remover 14** or acetone.
6. Can be disassembled with standard hand tools.

Storage

Cyanoacrylate adhesives must be stored under refrigeration at a temperature of 40°F ± 5°F for extended shelf life. Before opening, the containers must be warmed to room temperature, otherwise, water may condense into the bottle and cause hardening of the adhesive. To prevent contamination of unused adhesive, do not return product to its original container.

Dispensing Equipment

Hernon[®] offers a complete line of semi and fully automated dispensing equipment. Contact **Hernon[®] Sales** for additional information.

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